



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

K10004

Job Sheet 176702



Part No: K10004

Job Qty: 1 ea

Part Name: Heavy Duty Saddles



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/27/18

Job Tracking No:

Due Date: 5/7/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV E IPP : D 05.07.22 Reformat; Added D3428-3 per CHG003 KJ/JLM IPP Rev:E 08-09-29 revD as per dwg DD verified by: IPP Rev:F chg005 DD 10.06.03 verf:JLM IPP REV:G 13.08.21 REMOVED D3428-3 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	5/7/18	5/7/18	0.00	0.00	Start Up Stores/Pkg-1	6	MAY 02 2018
105	Packaging	1 pcs	5/7/18	5/7/18	0.00	0.00	Packaging1-5	6	MAY 02 2018
110	QC	1 pcs	5/7/18	5/7/18	0.00	0.00	QC4	6	
115	DC	1 pcs	5/7/18	5/7/18	0.00	0.00	DC	6	
120	Packaging	1 pcs	5/7/18	5/7/18	0.00	0.00	Packaging3-2	6	
130	QC21-FG	1 Ea	5/7/18	5/7/18	0.00	0.00	QC21	6	MAY 03 2018

Part Op 115 - Photocopy bluefile for K10004, D205-594-011/-013/-015 & D412-652-011/-21 and type labels per PPP K10004
Descriptions: CHG005

120 - Location : FG129

Fg129

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-51A	Bolt	16 Ea (16 ea)	90-Start up Operation	505394M
AN5-15A	Bolt	32 Ea (32 ea)	90-Start up Operation	5053947
AN5-36A	Bolt	2 Ea (2 ea)	90-Start up Operation	5048202
AN5-42A	Bolt	2 Ea (2 ea)	90-Start up Operation	504158607
AN5-43A	Bolt	2 Ea (2 ea)	90-Start up Operation	5027727
AN5-45A	Bolt	2 Ea (2 ea)	90-Start up Operation	5054120
D2570	Bushing	32 Ea (32 ea)	90-Start up Operation	5050167x8250
D3407-041	Tow Ring	2 Ea (2 ea)	90-Start up Operation	5058326
D3417-5	Washer	4 Ea (4 ea)	90-Start up Operation	5046078x2 505983x2
D3456-1	Washer	2 Ea (2 ea)	90-Start up Operation	5046078x1 505328x1
D5951	Saddle	2 Ea (2 ea)	90-Start up Operation	5052488
D5953	Saddle	2 Ea (2 ea)	90-Start up Operation	5055418
D5955	Saddle	2 Ea (2 ea)	90-Start up Operation	5054573
D5957	Saddle	2 Ea (2 ea)	90-Start up Operation	50541705
MS21042L4	Nut	16 Ea (16 ea)	90-Start up Operation	5054118
MS21042L5	Nut	40 Ea (40 ea)	90-Start up Operation	5041167
MS21043-4	Nut	2 Ea (2 ea)	90-Start up Operation	5066069
NAS1149D0563J	Washer	80 Ea (80 ea)	90-Start up Operation	5038636
D205-641-011	Ground Handling Lugs	2 Ea (2 ea)	105-Packaging	5067706



Container No: S067759

Part: K10004

Job No: 176702

Serial No/Batch: S067759

Revision:

Inspector:

Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
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Date: 05/02/18

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Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-51A	16	230	0
	AN5-15A	32	153	0
	AN5-36A	2	168	0
	AN5-42A	2	10	0
	AN5-43A	2	70	0
	AN5-45A	2	16	0
	D2570	32	298	0
	D3407-041	2	28	0
	D3417-5	4	30	0
	D3456-1	2	101	0
	D5951	2	3	0
	D5953	2	3	0
	D5955	2	2	0
	D5957	2	2	0
	MS21042L4	16	3,064	0
	MS21042L5	40	930	0
	MS21043-4	2	1,109	0
	NAS1149D0563J	80	1,531	0
	D205-641-011	2	0	0
105-Packaging				

Part Specifications

Specifications could not be found.

Plex 4/27/18 1:49 PM dart.lacelle.linda



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
002985	S067755	AN4-51A	Bolt	S053944	ST340	16
002985	S067752	AN5-15A	Bolt	s053947	OVER003	32
002985	S067751	AN5-36A	Bolt	S048292	ST336	2
002985	S067750	AN5-42A	Bolt	fm138607	ST336	2
002985	S067749	AN5-43A	Bolt	s027727	ST336	2
002985	S067748	AN5-45A	Bolt	s054120	ST335	2
002985	S050169	D2570	Bushing	S050168	ST008	9
002985	S067718	D2570	Bushing	S067705	ST008	23
002985	S067719	D3407-041	Tow Ring	S058326	ST530	2
002985	S066078	D3417-5	Washer	F159007	ST034	2
002985	S067747	D3417-5	Washer	S059573	ST034	2
002985	S066079	D3456-1	Washer	F159007	ST036	1
002985	S067721	D5951	Saddle	S052488	ST399	2
002985	S067720	D5953	Saddle	S055148	ST399	2
002985	S054573	D5955	Saddle	S054574	ST399	2
002985	S054705	D5957	Saddle	S054704	ST399	2
002985	S067744	MS21042L4	Nut	s054118	ST303	16
002985	S067743	MS21042L5	Nut	s041167	ST303	40
002985	S067740	MS21043-4	Nut	S066069	ST302	2
002985	S067737	NAS1149D0563J	Washer	s039036	ST263	80

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 5/2/18 1:51 PM dart.quirion.sonia

Change Record

Part Number K10004
Description SADDLE KIT

Page 1 of 1

Chg.	Date	By	Relevant Documents
001	00.06.06	DS	USED D2707-041 TDW RINGS
002	00.06.06	DS	CHANGE TO D2868-041 TDW RING SEE K10004 REV. A
003	05.07.22	KJS PH	ADDED D3428-3 PLACARD SEE K10004 REV. C
004	08.09.23	AG	DSI 9423 Rev.A, K10004 Rev.D D3407-045 TDW RING (ECN 08-540)
005	09.02.02	AG	K10004 Rev.E (ECN 09-514)

QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER :																			

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING
LANDING GEAR INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 412	D412-652-011 D412-652-021
BELL 205/212/214	D205-594-011 D205-594-013 D205-594-015
BELL 204	D205-594-021 D205-594-023

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE
FOLLOWING TABLE (REF):

PART NUMBER	K10004	D412-652-011 D412-652-021	D205-594-011 D205-594-013 D205-594-015 D205-594-021 D205-594-023
D205-641-011	2	2	2
D2570	32	32	32
D3407-041	2	2	2
D3417-5	4	4	4
D3428-3*	1	N/A	1
D3456-1	2	2	2
D5951	2	2	2
D5953	2	2	2
D5955	2	2	2
D5957	2	2	2
AN4-51A	16	16	16
AN5-15A	32	32	32
AN5-36A	2	2	2
AN5-42A	2	2	2
AN5-43A	2	2	2
AN5-45A	2	2	2
AN960JD516	80	80	80
MS21042-4 (OR L4)	16	16	16
MS21042-5 (OR L5)	40	40	40
MS21043-4	2	2	2

*REQUIRED WITH D205-594-011/-013 INSTALLATIONS ON 214 AIRCRAFT ONLY

E	D3407-041 WAS D3407-045; REMOVE D3812-1; REASON: TOW RING IS CHANGED ON D205-634-011/ D204- 635-011 SKIDTUBES @ CHG 007 AND D205-634-015 SKIDTUBES @ CHG 006. SEE DSI 9417/9418 @ REV. B	PH	09.01.28
D	D3407-045 WAS D2707-041; D3456-1 WAS AN970-4; MS21043-4 REPLACES MS21042-4 (QTY 2); ADD D3417-5 AND D3812-1; ADD REFERENCE TO D205-594-021/-023	PH	08.09.11
C	ADD D3428-3 PLACARD	PH	05.07.22
B	ADD D2707-041 OPTION	DS	00.11.22
A	NEW ISSUE	DS	00.06.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		K10004	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SADDLE KIT	NTS
DATE	09.01.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	